Dart Aerospace Ltd. Friday, 22/05/2009 4:45:44 PM 'Date: User: • Julie Dawson **Process Sheet** : "T" HANDLE ASSEMBLY : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 48154A **Estimate Number** : 11179 : D2282041 P.O. Number Part Number : D2282 REV E : 22/05/2009 S.O. No. : **Drawing Number** This Issue : NC : N/A Prsht Rev. **Project Number** : // : SMALL /MED FAB ; E First Issue Type **Drawing Revision** : 47861A Previous Run Material **Due Date** : 19/06/2009 Qty: 50 Um: Written By Checked & Approved By : Est Rev:A Removed from 9 Digit 05-12-02 JLM Comment **Additional Product** Job Number: Seq. #: Description: **Machine Or Operation:** D22823 Tube 1.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s) Pick: Description Batch **Qty Part Number** Handle tube B41a1089.=50X1 D2282-3 D22825 2.0 Tube Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s) Pick: **Qty Part Number** Description Batch Handle tube 54 1 D2282-5 3.0 LARGE FAB 1 Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration as per dwg D2282

******brush weld right after welding, to take color off ******

A/R ER316L SS Filling Rod M102421 Dwg Rev: _E___

9.06.08

Each

Dart	Aeros	pace	Ltd
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W/O:			WC	RK ORDER CHANGE	S		***************************************		
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					1				
									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	4 :	Date:	
	Res	solution:	Disposition	n:	QA: N/C Cld	sed:		Date: _	···
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
•									

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:44 PM Julie Dawson User: **Process Sheet** Drawing Name: "T" HANDLE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 48154A Part Number: D2282041 Job Number: Seq. #: Description: **Machine Or Operation:** VISUAL WELDING INSPECTION 4.0 QC9 **Comment: VISUAL WELDING INSPECTION** SMALL FAB 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 09 PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion 09-06-09

Form: rprocess

Page 2

And book to all

W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,				
							i.
					-		
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	

Resolution:		Disposition	l: (QA: N/C Clos	osed: Date:		
WORK ORDER NON-CONFORMANCE (NCR				CE (NCR)			
	Description of NC		Corrective Action Section B	- В	Verification	Approval	Annyoval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
					-		
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Corrective Action Section Initial Action Description	WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Action Description Sign &	WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Action Description Section C Section C	WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Action Description Section C S

NOTE: Date & initial all entries

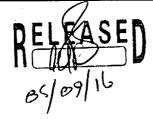
DART AEROSPACE LTD	Work Order:	48154A	
"	(NT DEOL)	B 441	lana Au
Description: Handle	[114204]	Part Number:	179787-011
Inspection Dwg: 12282 Rev:			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic		Proto			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	.Coi	mments
1.187	* 0.010	1.185			Vern		
	For	Weld	ding		q		
	M	950	54	7			
	/)
				7			
Measured by:	W	Audited by:		, 	Prototype Ap	proval:	N/A
Date:	04/04/04	Date:	J9:Us	uj [Date:	N/A
Rev Date	Change New Issue					vised by JLM	Approved



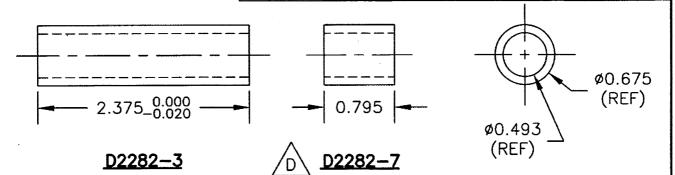
DESIG	BW .	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	(ED:	APPROVED	DRAWING NO.	REV. E
	a	1000	D2282 SHEET	1 OF 2
DATE		•	TITLE	SCALE
05.0	6.07		HANDLE TUBES	1:1
Α		94.10.14	NEW ISSUE	
В		95.03.23	RE-DESIGN	
C		97.10.20	CORRECTED NUMBERING SCHEME	



05.06.07		HANDLE TODES
Α	94.10.14	NEW ISSUE
В	95.03.23	RE-DESIGN
С	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030

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D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED R0.063 x 0.063 DEEP $0.090 \times 45^{\circ}$ 0.95 -**CHAMFER** 0.158 Ø0.700 R0.350 -Ø0.386 0.125 $0.080 \times 45^{\circ}$ (REF) **CHAMFER**

D2282-5

D2282-5 STEM:

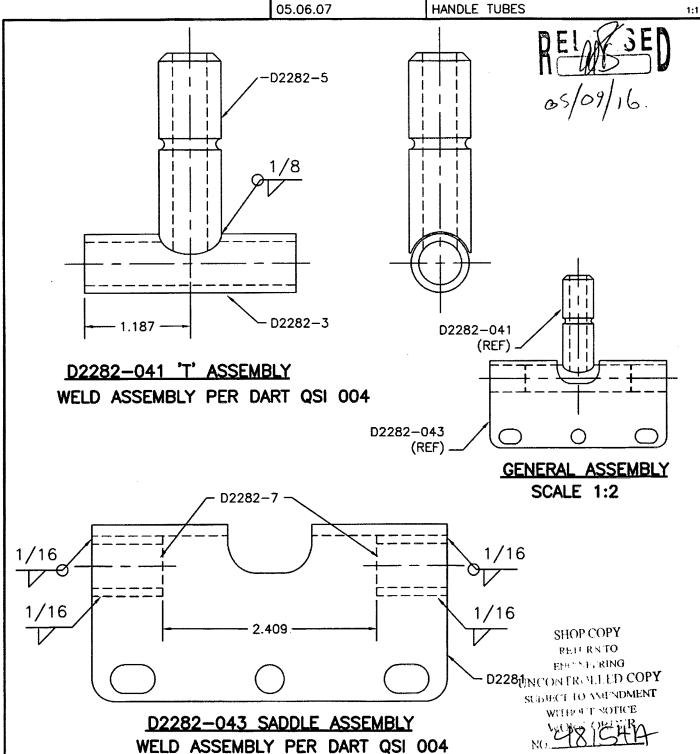
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED	DRAWING NO.	REV. E
l U	1 and	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



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